

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006716**Date Inspected:** 17-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 2100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 530**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, Oregon**CWI Name:** Jon Nickolich, Mike Gregson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Hinge K Pipe Beams**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Oregon Iron Works, Inc. (OIW) jobsite in Clackamas, Oregon for the purpose of observing fabrication of the Hinge K Pipe Beams.

OIW Fabrication Shop-Bay 3 (sub-assembly):

QA Inspector Brannon randomly observed OIW qualified welder Mr. Jayson Sinsel Heaton ID#S58 and one helper welding joining hinge K pipe beam gusset plates MK#a107 (HPS 485 W) to base plate MK#a110-4 (HPS 485 W) for hinge k pipe beam section 102A-4. The fillet weld is identified as weld joint #W2-14. Mr. Heaton was observed welding in the 2F (horizontal) position utilizing submerged arc welding (SAW) process with a 2.4mm diameter electrode, filler metal brand Lincoln Electric LA85 class F9A4-Eni5-G-H2. QA Inspector Brannon observed the OIW QC CWI Inspector Mr. Jon Nickolich verifying that the pre-heat and welding parameters were in accordance with the Welding Procedure Specification (WPS). Welding parameters measured by QA are as follows: 500 amps, 33.0 volts and a travel speed of 483mm per minute appear to be in conformance with approved welding procedure specification WPS 4020 revision number 0.

OIW Fabrication Shop-Bay 3 (sub-assembly):

QA Inspector Brannon randomly observed OIW qualified welder Mr. Jayson Sinsel Heaton ID#S58 and one helper welding joining hinge K pipe beam gusset plates MK#b106 (HPS 485 W) to base plate MK#a110-4 (HPS 485 W) for hinge k pipe beam section 102A-4. The fillet weld is identified as weld joint #W2-16. Mr. Heaton was observed welding in the 2F (horizontal) position utilizing submerged arc welding (SAW) process with a 2.4mm diameter electrode, filler metal brand Lincoln Electric LA85 class F9A4-Eni5-G-H2. QA Inspector Brannon observed the OIW QC CWI Inspector Mr. Mike Gregson verifying that the pre-heat and welding parameters were

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

in accordance with the Welding Procedure Specification (WPS). Welding parameters measured by QA are as follows: 501 amps, 32.9 volts and a travel speed of 483mm per minute appear to be in conformance with approved welding procedure specification WPS 4020 revision number 0.

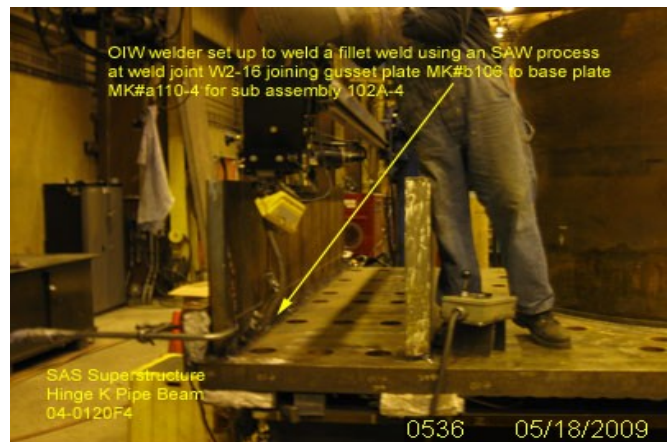
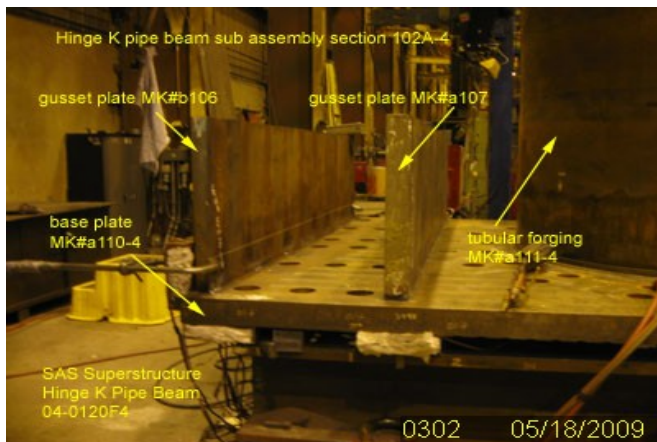
Caltrans Status and Production Tracking:

QA Inspector Brannon also updated Caltrans status and production tracking logs for tracking of check samples, procedure qualification record (PQR), critical weld repairs (CWR), non-critical welding repairs (WRR), completed and in process welding, QC/QA non-destructive testing.

Material, Equipment, and Labor Tracking:

QA Inspector Brannon performed a verification of personnel at OIW. QA Inspector Brannon observed 1 Supervisor, 2 Quality Control and 2 production personnel on this date.

The following digital photograph below illustrates observation of the activities being performed.



Summary of Conversations:

No relevant conversations to report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon, Sherri	Quality Assurance Inspector
Reviewed By:	Adame, Joe	QA Reviewer
